

Date: Friday, 15/05/2009 1:54:30 PM  
 User: Melanie Fauteux

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PLATE, ANCHOR  
 Job Number : 47981  
 Estimate Number : 13934  
 P.O. Number :  
 This Issue : 15/05/2009 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : R & D SM/MED FAB  
 Previous Run :  
 Written By :  
 Checked & Approved By : MF 09-05-15  
 Comment : Est Rev:A 08-09-18 new issue DD verified by:EC

Part Number : D3948041  
 Drawing Number : D3948 PROTO  
 Project Number : N/A  
 Drawing Revision : PROTO 09-05-15  
 Material :  
 Due Date : 22/05/2009 Qty: 6 Um: Each

## Additional Product

PRO-STATE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S040 6061-T6 .040 Sheet



Comment: Qty.: 0.1155 sf(s)/Unit Total: 0.6930 sf(s)  
 6061-T6 .040 Sheet  
 batch: 109396 1B 9-5-19

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3948-1  
 Dwg Rev: PROTO  
 Prog Rev: TYPE 1B 9-5-19

⑧

2-Deburr if necessary 1B 9-5-19

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

20/05/20 ⑧

09-05-20

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- countersink holes as per dwg

2- deburr if necessary

09/05/21 ⑧



Date: Friday, 15/05/2009 1:54:30 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE, ANCHOR

Job Number: 47981

Part Number: D3948041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING  
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

MS21059L3

Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut Plate

batch: 4109962

10.0

MS20426AD373

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

RIVET

batch: 17681

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- install anchor nuts and rivets as per dwg

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: \_\_\_\_\_

**FOR ENGINEERING USE ONLY**

**FOR ENG USE ONLY**

Date: Friday, 15/05/2009 11:54:30 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE, ANCHOR

Job Number: 47981

Part Number: D3948041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09-05-22 Prototype*

Job Completion



*00280A*

*MF 09-06-04*

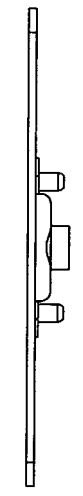
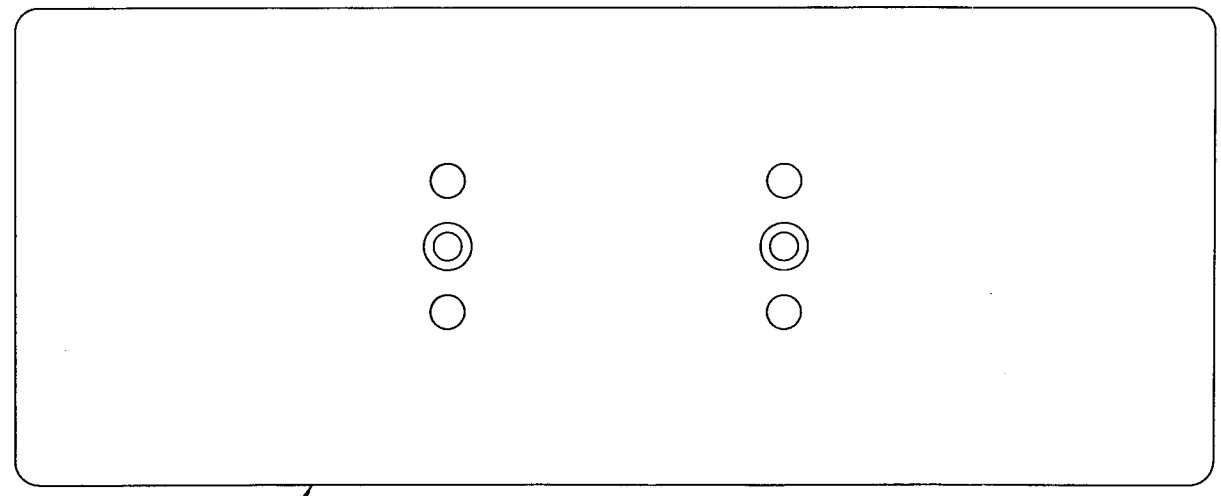
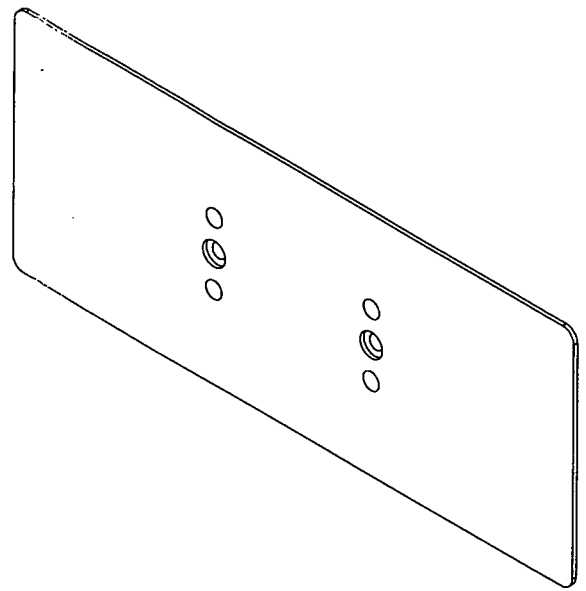




PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3948-041	PLATE, ANCHOR
2	1	D3948-1	PLATE
3	2	MS21059L3	NUTPLATE (OR MS21059-3)
4	4	MS20426AD3-3	RIVET

PROTOTYPE  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
09.05.13



D3948-1

**D3948-041 PLATE, ANCHOR**

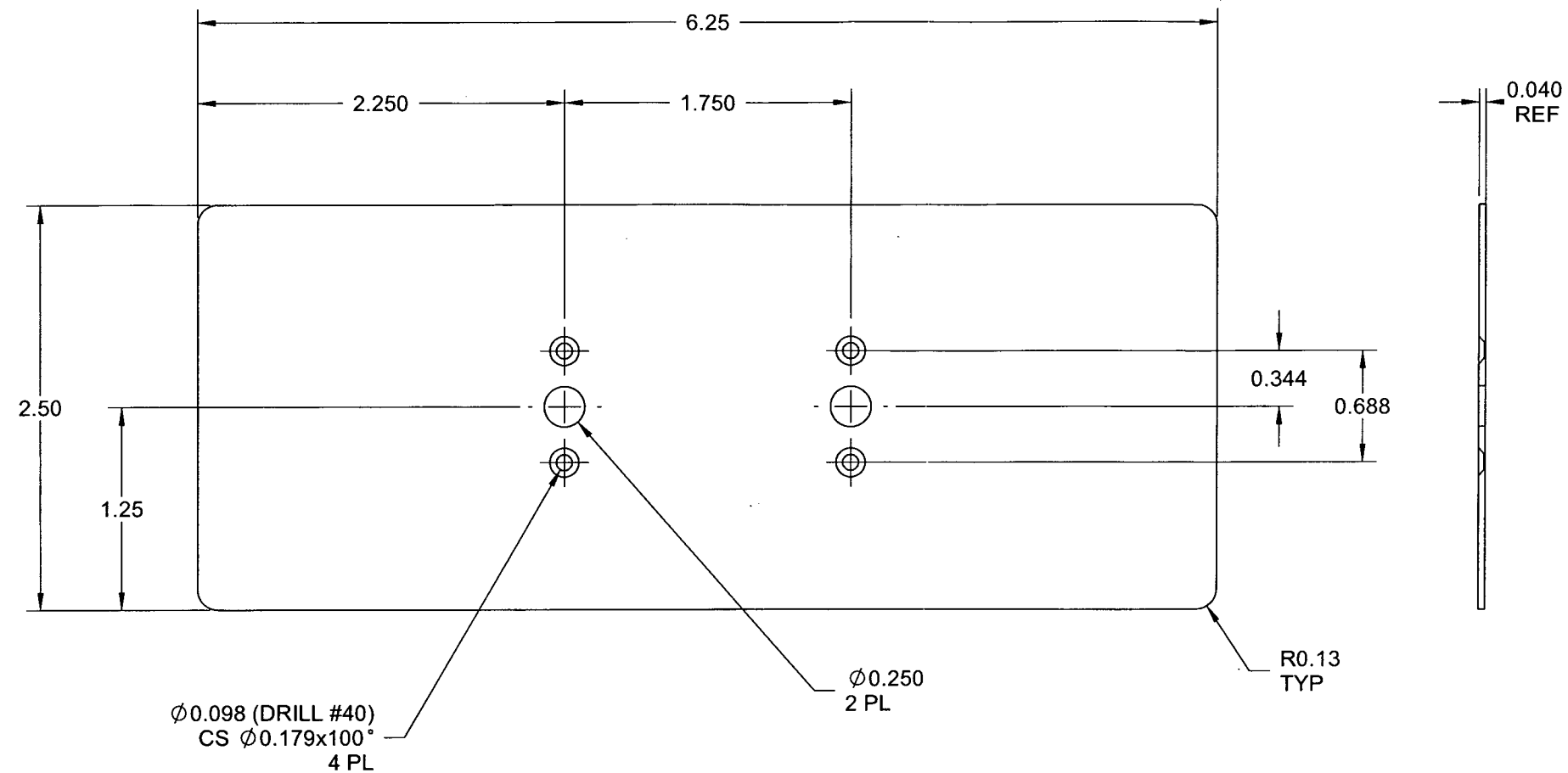
- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: NONE
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3948-041" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.06 lbs

A	NEW ISSUE	CP	09.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	gp	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	gp		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3948	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		PLATE, ANCHOR	NTS
DATE	09.05.13	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

D

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
*GP* 09.05.13



8 7 6 5 4 3 2 1

A

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.040" THICK PER AMS-QQ-A-250/11 (REF DART SPEC. M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 004 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs

DESIGN	<i>GP</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>GP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3948</b>	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>PLATE, ANCHOR</b>	NTS
DATE	<b>09.05.13</b>	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	